

# Work Order ID 76951

November-24-11 11:22:15 AM

**\*76951\***

Page 1

Item ID: D1048

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle

Start Date: 24/11/2011 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 01/12/2011 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/11/24

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D1048	Rev A								

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D1048

Set .053

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B11-12-2



110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

B11-12-2

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

11 - 12 - 02 56

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 76951

**\*76951\***

November-24-11 11:22:15 AM

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Item ID: D1048 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Saddle  
Start Date: 24/11/2011 Start Qty: 20.00 **\*20\*** Cust Item ID:  
Required Date: 01/12/2011 Req'd Qty: 20.00 **\*20\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.								
140		0.00							
<b>*140*</b>	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Form as per dwg D2010 using DT8053								
150		0.00							
<b>*150*</b>	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

*Handwritten signature and date 11/12/06 with circled number 56.*

*Handwritten signature and date 11/12/06 with circled number 56 and initials.*

*Handwritten circled number 56.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: Small EAB NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: Scrap Disposition: Scrap QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/12/06	120-140	Qty +1 Part lost between Bcs a & b bcs. R.C. Loss when handling parts / not checked amounts. W/A						

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# Work Order ID 76951

**\*76951\***

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November-24-11 11:22:15 AM

Item ID: D1048 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle  
 Start Date: 24/11/2011 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 01/12/2011 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
<b>*160*</b> Powdercoat Powder Coating	Memo START TIME: 2:50 OVEN TEMPERATURE: 320°F FINISH TIME: 3:20	0.00							56X0M-11/12/06
170	QC3- Inspect Part Finish	0.00							
<b>*170*</b> QC Quality Control	Memo	0.00							36 BL 11-12-6
180	Identify as per dwg & Stock Location: GA	0.00							
<b>*180*</b> Packaging Packaging	Memo	0.00							12/2/7 (54)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 76951****\*76951\***

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Item ID: D1048

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Saddle

Stop **\*NS2\***

Start Date: 24/11/2011 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 01/12/2011 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00


**\*190\***

QC

Memo

0.00

Quality Control

11/12/11 MF  
11-12-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

November-24-11 11:22:19 AM

Page 1

Work Order ID: 76951

**\*76951\***

Parent Item: D1048

**\*D1048\***

Parent Item Name: Saddle

Start Date: 24/11/2011

Required Date: 01/12/2011

Start Qty: 20.00

Required Qty: 20.00

**Comments:**

IPP: B02.02.22Re-formatNG

IPP Rev:C Now on Waterjet 06-12-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

303.6000

0.018

0.378947

1,

**\*M304S16GA\***

**\*\***

B11-12-2

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

303.6

119346

26.6

119653

277

~~119346~~  
119653

SG

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

RELEASED  
9/10/07/02 RCL

NOTES:

1) MATERIAL

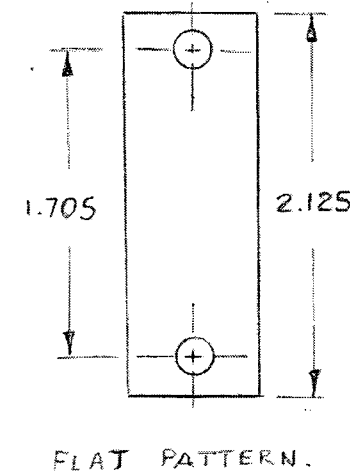
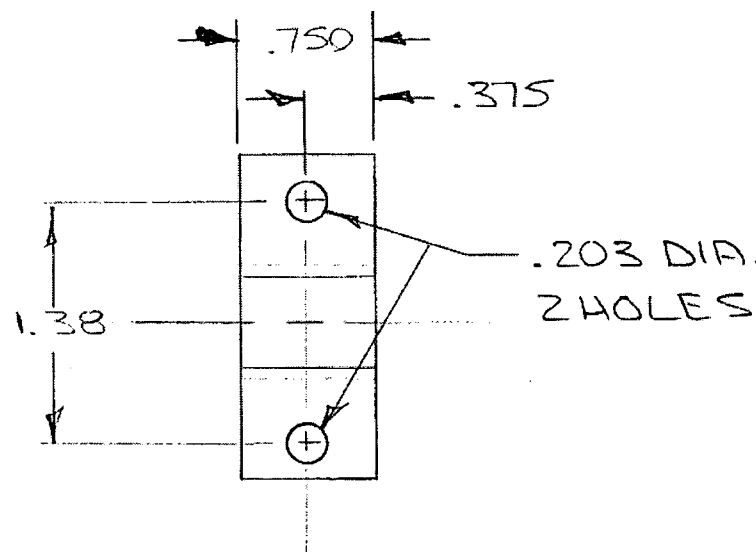
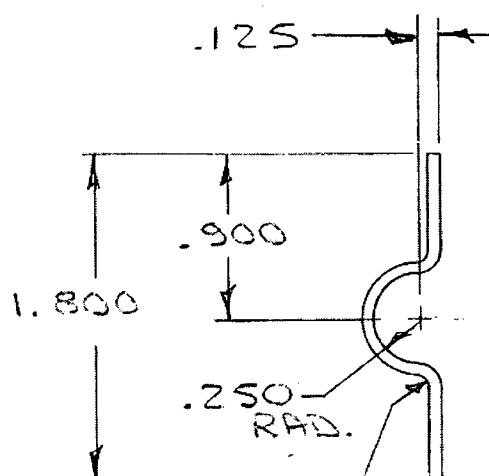
STAINLESS STEEL  
T304#2B .062 THICK

2) FINISH : POWDER COAT BLACK SANDTEX (REF. 4.3.5.7)  
PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.010 TO 0.020

SIR  
RETURNED  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 76951 M.C.J.  
11/11/24



A		REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 623		PART NO.		ITEM	DESCRIPTION	MATERIAL	SPEC./VENOOR
RF		DRAWN			BASIC CODE		CONTRACT NO.		DART AERO ACCESSORIES INC. VANCOUVER CANADA			
		APPROVED			D=DMPL DIGIT=NO OF SHEETS C=COUNTERSINK		DATE					
		DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		LENGTH DASH NO. W=SPOTWELD		DRAWN		DESIGN			
			GENERAL		BASIC CODES		DESIGN		STRESS			
			LIMITS		B=MS20470AD DB=MS20426AD		STRESS		CHECKED			
			1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER IN. — 5 — 3742 5. HOLES PER AND 10387		1. TOLERANCES — .XX ± .030 .XX ± .010 2. ANGLES .XX ± .010 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL HVC CENTRE LINES .005		TITLE		CLAMP			
			REPORT ALL DISCREPANCIES — DO NOT SCALE				CLIENT		D 1048			
									SCALE 1:1 SHT 1 OF 1			

D 1048

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries